

Date: Thursday, 4/12/2007 8:23:43 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BATTERY LOCK ASSEMBLY
 Job Number : 31667
 Estimate Number : 10900
 P.O. Number : N/A Part Number : D3393041
 This Issue : 4/12/2007 S.O. No. : N/A Drawing Number : D3393 UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 26701 Material : N/A
 Due Date : 4/13/2007 Qty: 3 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 05-11-22 JLM

REMOVE UNDER REVIEW
 DWG WAS REWORKED
 ON 05/07/07.
 07.04.12

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D27287 Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2728-7 Decal B22554

SAD

2.0 D33731 Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3373-1 Cam Lock B23643

SAD

3.0 516WC SS Flat Washer 5/16



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
 2 5/16WC SS Flat Washer B34137

M105403

SAD

P10

4.0 D33931 Battery Lock Casing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3393-1 Battery Lock Casing B23552

SB

07/10/23

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-10- 23	6	Applied crazy glue to 9567K21 , <u>B#17089</u> (6) rubber things. and stuck them in lock.	mf	07-10- 23	6		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:23:43 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 31667

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33933

Cam Lock Shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-3

Cam Lock Shaft

~~42294~~ B23536

SR 07/10/23

(3)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5

3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal.

A/RN/A262 Locktite

M1028155

4-Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key

Key Numbers

1- C420A

5- _____

2- C420A

6- _____

3- C420A

7- _____

4- _____

8- _____

SAD 07/10/22

(3)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack Weld lock shaft to flat cam of a Max 1/8" Long

Qty Part Number Description Batch

A/R N/A

SS Rod

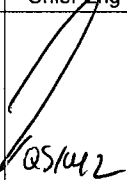

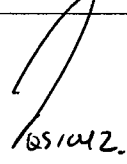

M105138

07.10.23

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/10/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/22	B.O	Key was scrap because it lock tight, key had some on it, so it lock the key holder and the key together. R.C! Human Error.	 Q51042	Scrap destroy replace	SAB 07/10/22	 07/10/23	 Q51042	 07/10/23

NOTE: Date & initial all entries

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Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 31667

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/10/23 (3)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/23 (3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/10/23

50 3x

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/23 (3)

Job Completion



U 07.10.23

Ship today

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



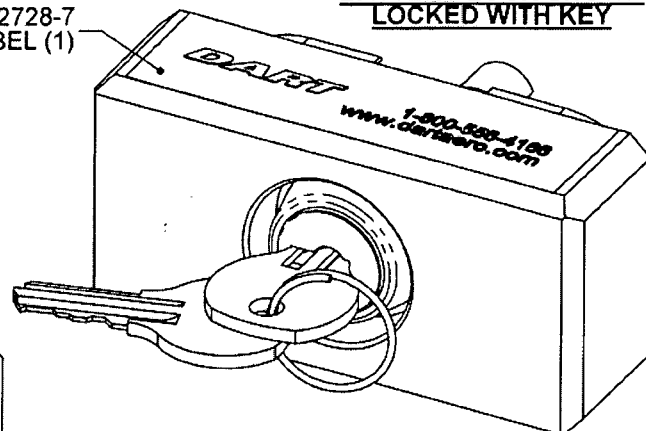
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CHECKED RF	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]

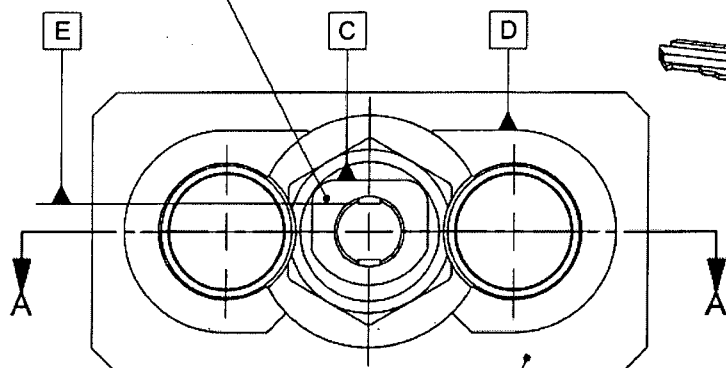
05/03/09

D2728-7
LABEL (1)

**BATTERY LOCK SHOWN
LOCKED WITH KEY**



POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWN



D3373-1
CAM LOCK
ASSEMBLY (1)

D3393-1
CASING (1)

Ø5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) Δ
AND APPLY KRAZY GLUE

0.09^{+0.03}
-0.01 (2 PLACES)

D3393-3 CAM
LOCK SHAFT (1)

TACK WELD
D3393-3 TO D3369-5

SECTION A-A

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

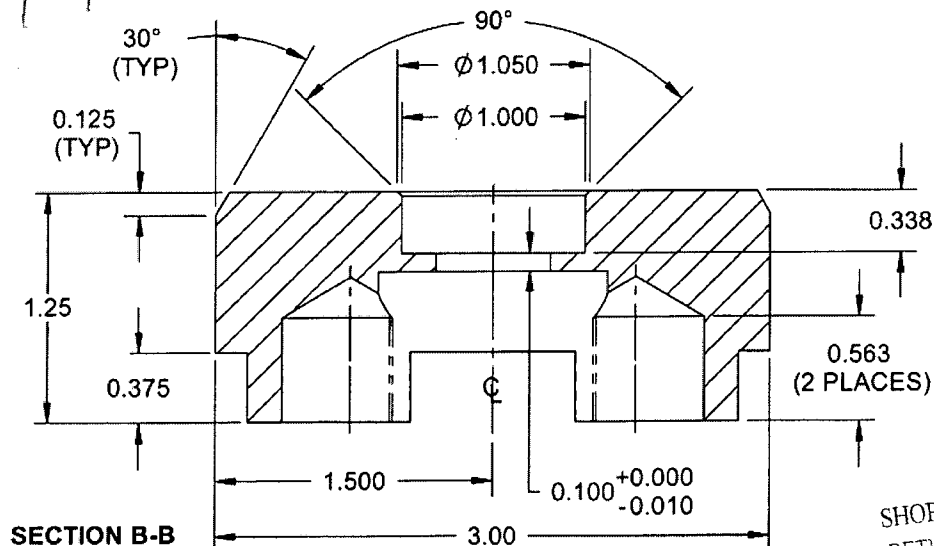
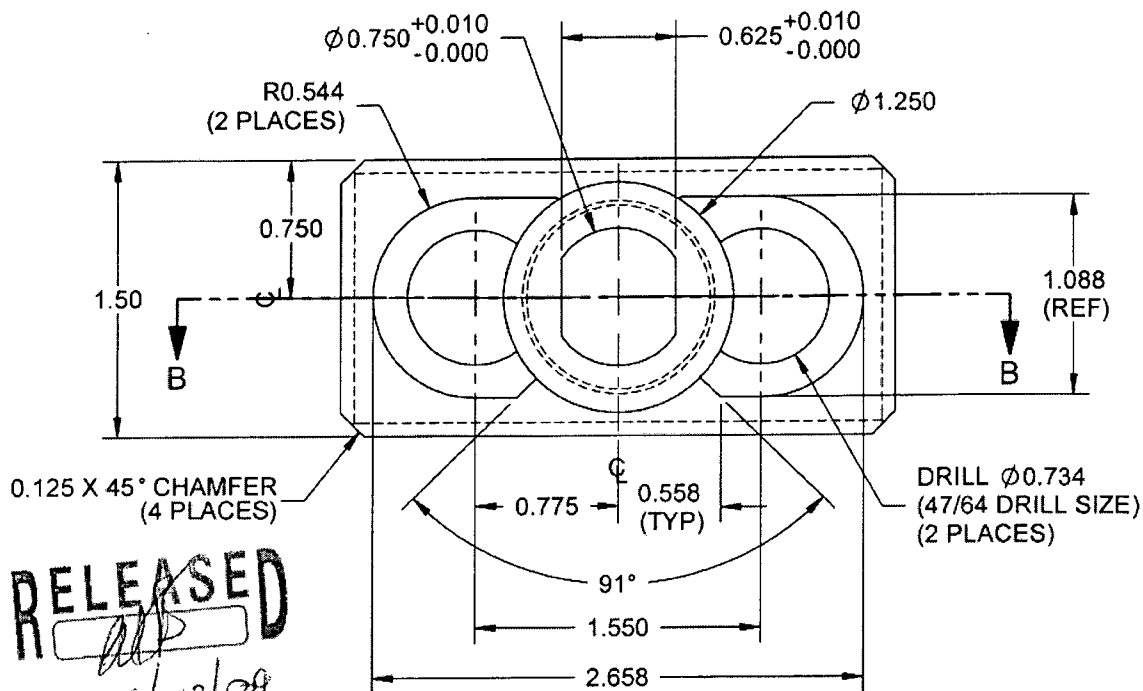
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CHECKED TH	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1

**SECTION B-B****D3393-1 CASING****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

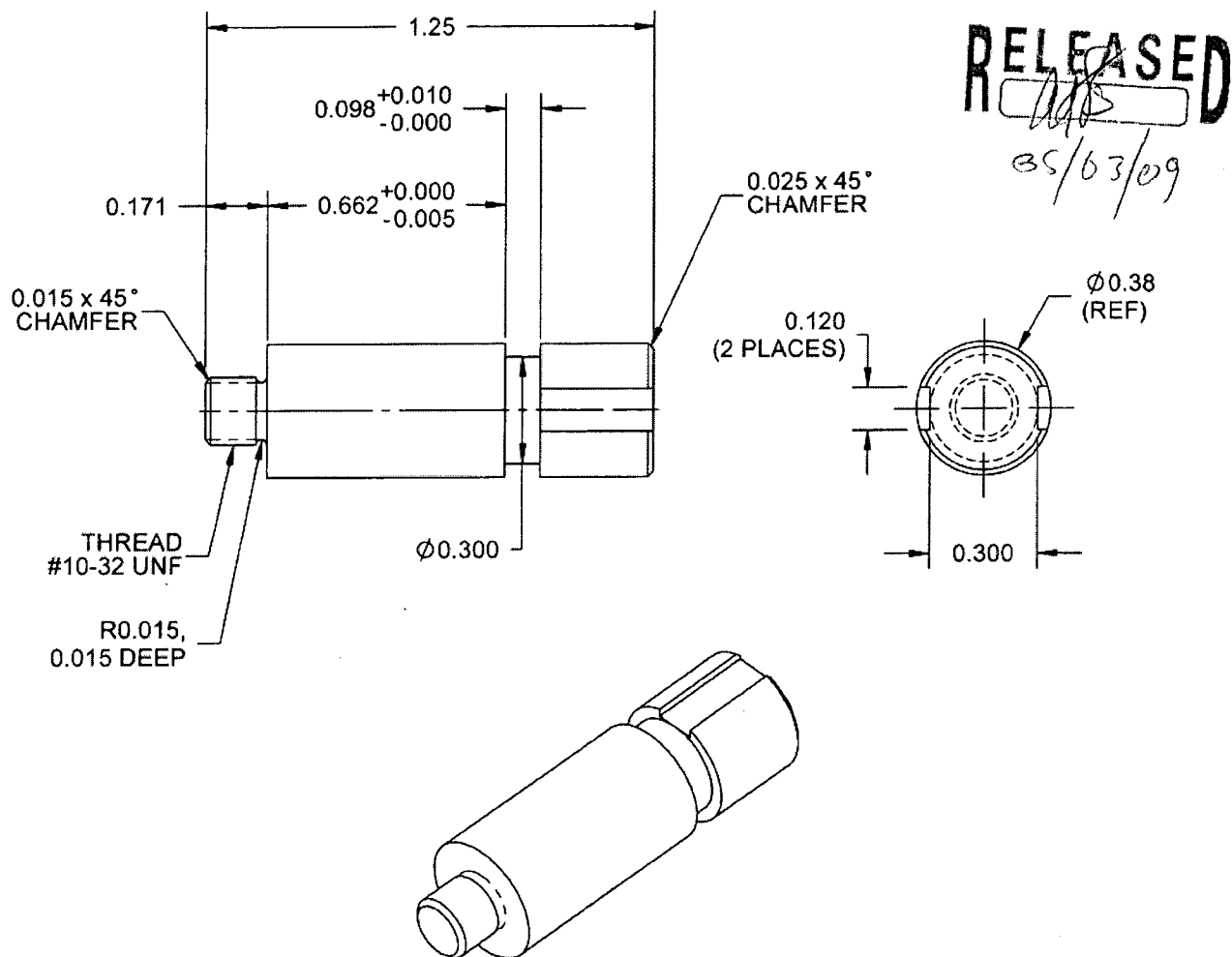
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DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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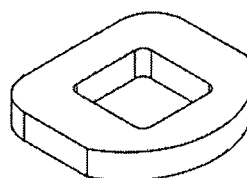
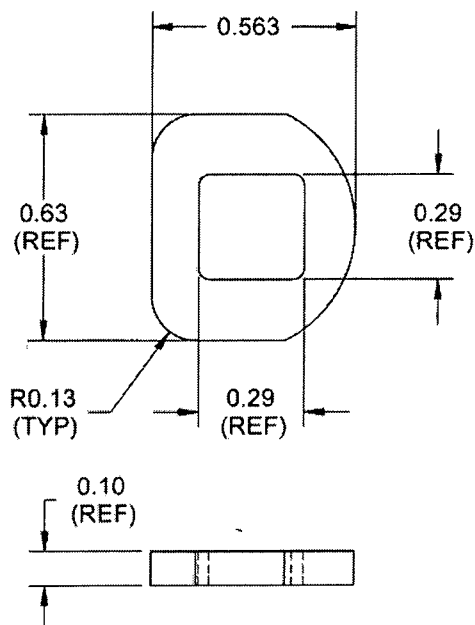
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]

05/02/11

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WITHOUT NOTICE
WORK ORDER
NO. 31667

-5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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